Work Order ID 95761

95761

January-18-13 10:26:27 AM

Item ID: D205-765-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Driveshaft Tunnel

Start Date: 2/07/13 **Start Qty:** 2.00 *2*

Required Date: 2/07/13 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-01-21 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
IIN D205-765	Rev A								
100		0.00				2			MLJ 13-4-10
100	DOCUMENT CONTROL								
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPPd205-765	CHG 001							
110	Pick Kit	0.00							
110									
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00				2			
120									
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D205-765-011 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Driveshaft Tunnel
Start Date: 2/07/13 **Start Qty:** 2.00 *2* **Cust Item ID:**
Required Date: 2/07/13 **Req'd Qty:** 2.00 *2* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00	Rack Loc 20		DAS 06 9-88	2x		13-4-11	
130									
Packaging	**Memo**	0.00							
Packaging	PACKAGE PER PPP								
140	QC21- Final Inspection - Work Order Release	0.00						13/4/12	
140									
QC	**Memo**	0.00							
Quality Control									

13-04-11

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Finish
- ☐ Folio
- ☐ Grain
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- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
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- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

January-18-13 10:26:26 AM

Work Order ID: 95761

Parent Item: D205-765-011

Parent Item Name: Driveshaft Tunnel

Start Date: 2/07/13 **Required Date:** 2/07/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A New Issue 08-03-17 JLM Verified By: LL
******MS20427M4 rivets are supplied by customer******

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A Bolt		Purchased	No			110	Each	726.0000	17	34			
				Location		**Loc Qty**		**Loc Code**					
				ST350		726							
					124028	726							
D3648-041 Driveshaft Tunnel Assembly		Manufactured	No			110	Each	0.0000	1	2			
D3654-1 Doubler		Manufactured	No			110	Each	1.0000	1	2			
				Location		**Loc Qty**		**Loc Code**					
				ST188		1							
					90625	1							
D3682-1 Gasket		Manufactured	No			110	Each	0.0000	1	2			
NAS1149C0363R Washer		Purchased	No			110	Each	3,491.0000	17	34			
				Location		**Loc Qty**		**Loc Code**					
				FP001		1134							
					114742	1134							
				ST292		2357							
					114742	309							
					122063	48							
					122441	2000							

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NCR: Yes / No

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Work Order: _____

Part No. _____

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- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
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- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Supplier	☐									
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

SmB REFERENCE ONLY
13 4 10

5. PARTS LIST

Qty 011	Part Number	Description
X	**D205-765-011**	**DRIVESHAFT TUNNEL KIT**
1	*D3648-041	TUNNEL ASSEMBLY
1	*D3649-041	TUNNEL BOTTOM PANEL ASSY.
1	**D3649-1	TUNNEL BOTTOM PANEL
22	**MS21060-3K	NUTPLATE
22	**MS21062-3K	NUTPLATE
88	**MS20427M3-3	RIVET
1	*D3650-041	TUNNEL TOP PANEL ASSY.
1	**D3650-1	AFT PANEL
1	**D3650-3	CENTER PANEL
1	**D3650-5	FWD PANEL
8	**AN3C-3A	BOLT
8	**AN960C10	WASHER
1	*D3651-041	AFT BASE ASSEMBLY
1	**D3651-043	FLANGE WELDMENT
1	**D3651-1	GASKET
1	**D3651-9	INSIDE DOUBLER
1	**D3651-11	GASKET
1	**D3651-13	OUTSIDE DOUBLER
58	**CR3523-4-02	RIVET
40	*AN3C-3A	BOLT
40	*AN960C10	WASHER
1	*D3654-1	DOUBLER
1	*D3682-1	GASKET
17	AN3C-3A	BOLT
17	AN960C10	WASHER
A/R	MS20427M4	RIVET

* PART IS INCLUDED WITH D3648-041 TUNNEL ASSEMBLY
** PART IS INCLUDED WITH ASSEMBLY ABOVE

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Change Record

Part Number: D205-765-011

Description: DRIVESHAFT TUNNEL

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
001	08.03.27	KJ	MDL-D205-765 REV A	1161
002	12.10.09	KJ	DSI 9633 REV. A, D3650 REV. E	12-663